



Big Sky® Product Information Sheet

Technical Support (800) 328-4892

P.I. Sheet #2012

PS5620™ Metal-Etch Primer

READ ENTIRE PRODUCT INFORMATION SHEET PRIOR TO USE. IF ANY QUESTIONS ARISE, PLEASE CALL TECHNICAL SUPPORT.

COMPONENTS (REQUIRED)



1. PS5620™ Metal-Etch Primer
2. TH0800™ Series Urethane Grade Reducer

SPECIALTY COMPONENTS (OPTIONAL)

1. None Recommended

DESCRIPTION:

PS5620™ is a direct to Metal Self Etching Primer designed to provide adhesion and corrosion protection to Steel, Aluminum, and Galvanized surfaces that have been properly cleaned and free of rust, grease, oils, and contaminants. Compatible with all of today's automotive and fleet finishes.

SURFACE PREPARATION

NOTE: Be sure to completely remove all rust or oxidation prior to applying primer. Rust and/or oxidation can be removed by sand blasting, grinding, or sanding. Liquid metal cleaners may also be used.

DO NOT USE A PHOSPHATE CONVERSION COATING PRIOR TO USING PS5620™ METAL-ETCH PRIMER.

Bare Substrates:

- Solvent clean with TH5950™ Strong Wax & Grease Remover or TH5951™ Mild Wax & Grease Remover.
- Finish sand with 180 grit sandpaper.
- Re-clean to remove sanding residue with TH5950™ Strong Wax and Grease Remover.
- TH5950™ Cleaner and a red scuff pad may be used to remove light surface oxidation on aluminum. Follow by re-cleaning the aluminum with TH5950™ Strong Wax & Grease Remover.

Pre-painted Substrates:

- Wash the surface with mild detergent and hot water, making sure to rinse well and dry with a clean, dry cloth. Solvent clean with TH5950™ Strong Wax & Grease Remover or TH5951™ Mild Wax & Grease Remover.
- Sand repair area and featheredge as needed, finishing with 320 grit sandpaper.
- Re-clean repair with TH5951™ Mild Wax & Grease Remover or TH5952™ Fast Evaporating Final Cleaner to remove sanding residue before priming.

COMPATIBLE SUBSTRATES

- Properly cleaned steel, aluminum, and galvanized steel
- Thoroughly sanded and cured paint adjoining metal
- Cured body filler

MIX BY VOLUME



- 2 Part Metal-Etch Primer (PS5620™)
- 1 TH0860™ and TH0870™ Urethane Grade Reducer

Mix Ratio in Ounces (Mixed 2:1)						
Primer	4	8	12	16	24	32
Reducer	2	4	6	8	12	16

TINTING

- Not recommended

POT LIFE



- 5 days once reduced with TH0800™ Series Urethane Grade Reducer.
- Occasional stirring may be needed to keep a uniform mix.
- Keep lid tightly closed on container to prevent solvent evaporation.

ADDITIVES

- Not recommended

EQUIPMENT SETUP



	Fluid Tip	Air Pressure
HVLP Gravity	1.3 – 1.5 mm	5 – 7 PSI at the air cap
HVLP Siphon	1.4 – 1.6 mm	6 – 8 PSI at the air cap
High Efficiency Gravity	1.3 – 1.5 mm	30 – 40 (PSI) Inlet Pressure
High Efficiency Siphon	1.4 – 1.6 mm	30 – 40 (PSI) Inlet Pressure
Conventional Gravity	1.3 – 1.5 mm	35 – 45 (PSI) Inlet Pressure
Conventional Siphon	1.4 – 1.6 mm	35 – 45 (PSI) Inlet Pressure

PRIMER APPLICATION (SPRAY)



- Apply 1 – 2 medium coats to the clean and dry surface. Allow PS5620™ Primer to flash 10 minutes between coats.
- Protect adjacent surfaces from overspray.

Brushable / Rollable Option

- Mix according to directions.
- Apply 1 even coat of PS5620™ Metal-Etch Primer, making sure to cover the repair area completely into the featheredge.
- If a 2nd coat is applied, allow a 5-10 minute flash between coats.
- Apply the 2nd coat within the first coat's outer edge.
- Primer may need sanded to smooth out prior to topcoat or surfacing.

DRY TIME TO SAND

- Does not need sanded unless primer has dried for 24 hours.
- Use a gray scuff pad for best sanding results.

DRY TIME TO TOPCOAT

- 30 minutes at 75°F.

COMPATIBLE TOPCOATS

- Montana brand primer surfacers
- Montana brand sealers
- Montana brand color systems

SPECIAL NOTES

- Use in shop temperatures that are maintained above 75° for the first 20-hours of the dry cycle.
- Ensure surfaces are up to shop temperature prior to work.
- Ensure proper metal conditioning/preparation procedures in early stages are followed.
- Ensure proper flash times, dry times, sanding procedures, and all directions for topcoats are followed.
- Use a mixing cup for accurate volume measurements.
- Allow primer to flash between coats to ensure better drying.
- Excessive loading of this product can lead to cracking and shrinkage.
- Allow body fillers and heavily primed areas extended dry times.

PHYSICAL DATA

Mixed 2:1 with TH0800 Urethane Reducers	
Dry to Sand	Does not need sanded for first 24 hours
Dry to Topcoat	30 minutes
Film Thickness	.75 ± .2 mils per coat
Volume Solids	17.1%
VOC Applied	6.0 max
# of Coats	1 – 2
Theoretical Coverage	275 sq ft/gallon

CLEAN-UP

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

DISPOSAL

Dispose of all paint and paint related materials in accordance with state and local regulations.

SAFETY & HEALTH

Read and follow all technical product information, labels, and MSDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

MSDS REFERENCE

Primer – MSDS # 9
Reducer – MSDS # 1

COMPANY INFORMATION

ChemSpec USA
9287 Smucker Road
Orrville, Ohio 44667
Toll Free: (800) 328-4892
Fax: (330) 669-3965
Website: www.chemspec.co.za
www.montanabigsky.com

Refer to all labels on products and information sheets for hazards and proper handling procedures for each component. Read the Material Safety Data Sheets (MSDS) supplied with the materials.

KEEP OUT OF REACH OF CHILDREN